Work Order ID 84098 Page 1 May-02-12 4:17:57 PM D412-664-203 Item ID: Accept *N900040100* Setup **Revision ID:** Item Name: Crosstube Aft Start Date: 02/05/2012 Start Oty: 1.00 **Cust Item ID: Required Date:** 22/05/2012 Reg'd Oty: 1.00 **Customer:** Reference: Run Approvals: Process Plan: メムブ Date: 12/05/02 Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID **Description Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D412-664-243 E/DEO Photocopy bluefile and create labels as per PPP D412-664-203 CHG 008 JB Salaho CHG 008 JB . 0.00 100 DOCUMENT CONTROL *100* DC Document Control 110 0.00 Packaging *110* Packaging 0.00 Memo Packaging 120 0.00 Ray MO 12-6-25 BENDING MACHINE CROSSTUBES *120*

0.00

· Bend tube as per Dwg D412-664-243 using CNC bender program 412-aft and

Memo

Folio FT010

CNC Bend 2

CNC Alpha 160 Bender

	WORK ORDER CH	WORK ORDER CHANGES							
STEP PROCEDURE CHANGE By Date						Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				•					
			1.0	\					
				A					
	STEP				STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr		

Part No: F	PAR #: Fault Catego	ory: NCR: Yes No	DQA: Date:	
Resolution:	Disposition:	QA: N/C Close	d: Date:	

NCR:		W	ORK OR	DER NON-CONFORMANC	E (NCR)				
DATE	STEP	Description of NC		Corrective Action Section B		Verification	Approval	Approval	
DAIL	JILF	Section A			Sign & Date	Section C	Chief Eng	QC Inspector	
		crushing from bending is over tolerance at bother of bend	(1)	A 1.1.1 pol		A	(()	A	
17/1/15	120	15 over tolerang		sceptible po		1206-25			
(0)010	10	of bothm of head	12/6/25	Ucceptible per affiched SR		1206-23	1	12 0625	
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Work Orde <i>May-02-12 4:17</i>		098		*840	198*						Page 2	
Revision ID:	D412-664-20 Crosstube Aft)3		Accept	*N90	೧ ೧4೧	100)*	Setup Sta	1.7	S1* S2*	
Start Date: Required Date: Reference:	02/05/2012 22/05/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Iter							
Approvals:		n:		Tooling: SPC (Y/N):		Date:			Run Sta		R1* R2*	
Sequence ID/ Work Center ID 130 *130* QC Quality Control	•	Operation Description QC15- Crosstube Dimen Memo	nsional Check	Set Up/ Run Hours 0.00	Tool II	Tool#	Plan Code	Accept Qty	Qty	Reject Number	Insp. Stamp	
140 *140* Crosstubes		Crosstubes Memo		0.00						·		
Crosstubes				D412-664-243 using drill #9 holes as per OSI 10 to		\rangle	J\	10	12-	6-25	-	

DT8551 and drill table DT8577 using #9 holes as per QSI 10 to install towers.

2-Ream hole to finish size in tube as per Dwg D412-664-243using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-SCRIBE PART # & BATCH #

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

W/O:			V	VORK ORDER CHANGI	ES			•			
DATE	STEP	PROC	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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		1									
		:									
Part No		PAR #:	_ Fault Ca	tegory:	NCR: Yes No DQA: Date:						
	R	esolution:	_ Disposit	ion:	QA: N/C Cld	I/C Closed: Date:					
NCR:	*	W	ORK OR	DER NON-CONFORMA	NCE (NCR						
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval			
	U.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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Work Ord <i>May-02-12 4:1</i>		098		*84098*							Page 3		
Item ID: Revision ID:	D412-664-20	03		Accept	*N900	1040	100)* ፡	Setup Sta	rt *N	S1*		
Item Name:	Crosstube Aft								Sto	p *N	S2*		
Start Date:	02/05/2012	Start Qty: 1.00	*1*		Cust Item	ID:							
Required Date:	22/05/2012	Req'd Qty: 1.00	*1*		Customer:								
Reference:													
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:		F	Run Sta	1/1	R1*		
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*		
Sequence ID/ Work Center II	D	Operation Description Crosstubes Chemical Con	version	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
150 HandFXtube Hand Finishing Cro	sstubes	Memo	vo.sion	0.00 A									
160		QC3- Inspect Part Finish		0.00									
160 QC Quality Control		Memo		0.00				· · · · · · · · · · · · · · · · · · ·			Pho		
170		QC5- Inspect part complet	eness to step on W/O	0.00	116								
QC QC		Memo		0.00	4100								

Quality Control

Dart	Aeros	pace	Ltd
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W/O:	40.	WORK ORDER CHA	NGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Move Sfor 2150 + 2160 to 4th Selp					
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed	l:	Date:

NCR:	4		WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Vork Order ID 84098 (ay-02-12 4:17:57 PM			*84098*							Page 4		
Revision ID:	12-664-20 osstube Aft	93		Accept	*N900040100* Setup Start Stop						*NS1* *NS2*	
Start Date: 02/0 Required Date: 22/0 Reference:	/05/2012 /05/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:					14.7/		
		n:				ate:		Ĭ		Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		eject umber	Insp. Stamp
180		Outsource process - NDT	per QSI038 4.1	0.00								
180 Outsource2		Memo		0.00				C2	12/	06/	271	D
Outsource process - NDT	Γ	Issue P/O:	trant Inspection as per QS 7312 LPI as per AST ch copy of NDT results to	M 1417								
190				0.00								
190		Packaging										
Packaging		Memo		0.00					1	 -		
^o ackaging		•	ansit damage of NDT results attached t	o work order.					left	/2	7 (
200		QC5- Inspect part comple	eteness to step on W/O	0.00								1
200								/				MINA
QC		Memo		0.00								· · · · · · · · · · · · · · · · · · ·
Quality Control		Inspect for da	amage & ensure results ar	re as per Dwg D412-664-2	03							
57/04	176	pe chemical o	iont asperi	252005				1		H	1 /	2-6-27

se QC) inspect chuicol coal

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
		esolution:						
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B	Verification		Approval
		Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector
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	Work Order ID 84098 May-02-12 4:17:57 PM			*84098*					dichement 1977				Page 5		
Revision ID:	D412-664-20 Crosstube Aft	13				Accept		*N90	0040)*	Setup	Start Stop	1.71	S1* S2*
Start Date: Required Date: Reference:	02/05/2012 22/05/2012	Start Qty: Req'd Qty			*1* *1*			Cust Iten Customer							
Approvals:	Process Plan								Date:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 210 *21 \nabla* SprayPaint Spray Painting		**	emo *Mask under		rosstube as sho	0.00 0.00 wn***	Ĥours	Tool ID	Tool #	Plan Code	Accep Qty	Qt		Reject Number – 3	Insp. Stamp
		2- 00 PF St Fi P/ St		crosstube 74C 30 8:30 85	AS 12-7-1			1-243 and QSI 121687 122142 8:00 8:45							

220

QC14- Inspect Spray Paint

0.00

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Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

W 12 of 03 (1)

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
12107/04	210	PROTECTION ACCORDING TO DEO NO D417-664-243-E-1 IN CLEAR CORT.	g. Smith	12/07/04	}		Dit			

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:
NCR:	24	WC	ORK ORDER NON-CONFORMA	NCE (NCR)	

NCR:	CR: WORK ONDER NON-CONFORMANCE (NCh)							
		Description of NC		Corrective Action Section	n B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector
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Work Ord <i>May-02-12 4:1</i>		098		*84098*							Pag
Item ID: Revision ID: Item Name:	D412-664-20 Crosstube Aft			Accept	*N900	040	100) *	Setup Star Stop	I Z	S1*
Start Date: Required Date: Reference:	02/05/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1 [*]		Cust Item Customer:	ID:					
Approvals:	Process Pla	in:	Date:			ate:		1	Run Star Stop	17	R1*
Sequence ID/ Work Center II 230 *230* Crosstubes Crosstubes	D	Operation Description Crosstubes Memo Assemble a	s per Dwg D412-664-	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty A	Reject Qty	Reject Number	Insp. Stamp
		up. A/R Prose 2- Lightly s with 41058 3-Install su D12-664-2	Batch: 131 EXP: 11/1 EXP: 11/1 Excuff the bonded area u wash 'n' wipe pport with Scotch-Wel 33 using installation justich-Weld DP460 Ba	ising a 320 grit sand paper and d DP460 and install clamps as ig DT9024. Torque clamps as	I clean the area						

240

QC5- Inspect part completeness to step on W/O

0.00

240

Memo

0.0

Salalos

Quality Control

W/O:			W	ORK ORDER CHANG	ES			•
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA:	Date: _	
		esolution:						
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NCR)	,	
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order <i>May-02-12 4:17:57</i>		098		*840	198*							Page 7
Revision ID:	412-664-20 osstube Aft	3	. 2	Accept	*N900	0040	100)*	Setup	Start Stop	I VI	S1*
Required Date: 22/	/05/2012 /05/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:							
		n:	Date:			Date:			Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center ID 250		Operation Description Pick Kit		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept	Rej Qty		Reject Number	Insp. Stamp
250 Packaging Packaging		Мето		0.00								12/67/06 J
260 *260* QC Quality Control		QC4- 100% Inspect kits Memo	for completeness	0.00 EZLA	Xo			Q			-	
270 *270* Packaging Packaging		*****Ensu for application	pack for shipping as pere tube is not packaged on time & date ************************************	if curing time is less than 12	hrs, see step 27			_\X			(2	Sp 2-7-(2

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
						·			
Part No	·	PAR #:	Fault Cate	egory:	_ NCR: Ye	s No	DQA:	Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C	Closed:		Date: _	
NCR:		V	VORK ORE	DER NON-CONFORM	ANCE (NO	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Ve	rification	Approval	Approval
DAIL	SIEP	Section A	Initial Action Descrip Chief Eng Chief Eng		Sigr Da	ې ا&کا	Section C	Chief Eng	QC Inspector
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Work Ord <i>May-02-12 4:</i>	ler ID 84098 17:57 PM		*84098*			Page	
Item ID: Revision ID:	D412-664-203		Accept	*N900040100*	Setup Start	1/2/1	
Item Name:	Crosstube Aft				Stop	*NS2*	
Start Date: 02/05/2012 Start Qty: 1.00		*1*		Cust Item ID:			
Required Date	e: 22/05/2012 Req'd Qty: 1.00	*1*		Customer:			
Reference:		•					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	"NR1"	
	QC:	Date:	SPC (Y/N):	Date:	Stop	*NR2*	
Sequence ID/	Operation		Set Up/	Tool ID Tool # Plan Acco	ept Reject	Reject Insp.	

Run Hours

0.00

0.00

Work Center ID

280

Quality Control

280

Description

QC21- Final Inspection - Work Order Release

Memo

(X 12/7/le. MY 07-06

Number Stamp

Qty

Code

Qty

Page 8

Dart Ae	rospace	Lia							•
W/O:		,	WC	RK ORDER CHANGES					•
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date (Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory: I	NCR: Yes	No DQA:		_ Date:	
	Res	solution:	Disposition	n: (A: NC C	osed:		_ Date: _	
NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR	1)			
DATE	STEP	Description of NC		3	Verificati	ion	Approval	Approval QC Inspector	
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C			Chief Eng
l							1		1

Work Order ID: 84098

84098

Parent Item:

D412-664-203

Parent Item Name: Crosstube Aft

D412-664-203

Start Date: 02/05/2012

Required Date: 22/05/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:E04.02.16Reformat; Added D3189-1K/DS

IPP Rev:F06-03-29Remove Coments on Pick ListJLMIPP Rev:G06.12.08per ECN 886ECIPP Rev:H07-04-30As per Rev DJLM

IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC IPP rev J 11.04.21 DEO D412-664-243-E-1 EC verified DD IPP REV:K

11.10.03	DEO D412-664	-243-E-2	DD	verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-664-203TRN *D412-664 Crosstube Turning Detail	4-203TF	Manufactured	No	B85	389	110	Each	2.0000	**	1	JW	12	-6-20
				Location	1	Loc	Oty	Loc Code					
				LG003			2						
					83178		1		_				
					83179		1		_		_		
D2896-1		Manufactured	No			230	Each	26.0000	1	1			
D2896-1	k								**		Ag	12-7	
Support				Location	71502/10	yylos Loc	Otv	Loc Code		0			
				LG052			8				_		
					80586		8				_		
				LG053			18				_		
D3189-1			N.1		74465	•••	18		_		_		
		Manufactured	No			230	Each	12.0000	2	2	A n		
D3189-1	•								**		AR 1	2-7-	5
Chafing Shield				•	83972					(2)			
				Location		Loc	<u>Oty</u>	Loc Code					
				FG			4				_		
					36065		4				_		
				LG052			8				_		
					81060		8						

Dart	Aeros	pace	Ltd

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W/O:			WC	ORK ORDER CHA	ANGES	* * * * * * * * * * * * * * * * * * *				•
DATE	STEP	PRC	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
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NCR:		V		ER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action	Section B	0:	Verific	ation	Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Descrip	tion	Sign & Date	Section	on C	Chief Eng	QC Inspector
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Picklist Pri	nt
May-02-12 4:18	3:01 PM
Work Order ID:	84098
Parent Item:	D412-664-203
Parent Item Name	e: Crosstube Aft

84098

D412-664-203



D3595-063-570

Manufactured

No

230

163.0000

Start Qty: 1.00

**

Start Date: 02/05/2012

Required Qty: 1.00

Required Date: 22/05/2012

Al 12-7-5

RUBBER CUSHION

Location	<u>L</u> a	oc Oty	Loc Code		
FG		8			
37971		1			
42243		7			
LG		78			
83294		78			
MAT052		77			
71534		1			
76546		76			
	230	Each	92 0000	4	,

Each

MS21920-28

Purchased

No

230

Each

83.0000

**

Al 12-7-5

Clamp(per MIL-DTL-8783C)

Location	Loc Qty	Loc Code
FG	5	
105884	5	
LG050	58	
116839	2	
118713	4	
120054	2	
121067	50	
LG051	20	
121440	20	

(4)	

Dart Ae	rospace	Ltd							<i>.</i> .
W/O:			WC	ORK ORDER CHANGE	S				*
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·						
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	_ Date: _	
	Re	solution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORMAL	NCE (NCI	₹)			
DATE	0755	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	on C	Chief Eng	QC Inspector
						: : :			

Picklist Print May-02-12 4:18:02 PM										Page 3
Work Order ID: 84098		*Q	4098*							- - - - - - - - -
Parent Item: D412-664-203 Parent Item Name: Crosstube Aft)412-664-2	203*			tart Date: (Start Qty: 1		Required Da Required Q	te: 22/05/2012
MS21920-30	Purchased	No		230	Each	107.0000	•	2		
MS21920-30 clamp(per MIL-DTL-8783C)							**		AL 12	-7-5
			Location	Lo	oc Qty	Loc Code				
			LG		44			(2)		
			LG051		44 63				•	
			111258		14					
			121583		49				-	
AN6-40A	Purchased	No		250	Each	114.0000		4		
AN6-40A							**		JB_	
			Location	<u>L</u> c	oc Qty	Loc Code				
			ST342 120187		114					
			120187		66 4					
			121349		19				· 7/	
ANG 41 A	5 1 1	N T.	121584	250	25	55.0000		12/28	.4	_
AN6-41A	Purchased	No		250	Each	55.0000	2 **	2 $^{\prime}$		
AN6-41A							**		2B	
Don			<u>Location</u>	Lo	e Qty	Loc Code			-	
			ST342		55				_	
			119749		5			10.4170	i <i>a</i>	
AN960JD616 NAS1149D0663		No	120423	250	50	0.0000	10	12042	-	
	Purchased	No		250	Each	0.0000	18 **	18		
AN960.ID616							^^	12144	4 16	12/07/06
										\subseteq

Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES	,			•
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								
Part No	•	PAR #:	Fault Category:	NCR: Ye	s No DQ	A :	Date: _	<u> </u>
	Resolution	າ:	Disposition:	QA: N/C	Closed:		Date: _	

n Approval	Annuaval
	Approval QC Inspector

Picklist Print

May-02-12 4:18:02 PM

Work Order ID: 84098

Parent Item:

D412-664-203

Parent Item Name: Crosstube Aft

84098

D412-664-203

Start Date: 02/05/2012

Required Date: 22/05/2012

Start Qty: 1.00

**

Required Qty: 1.00

M\$21042L6

Purchased

No

250

Each

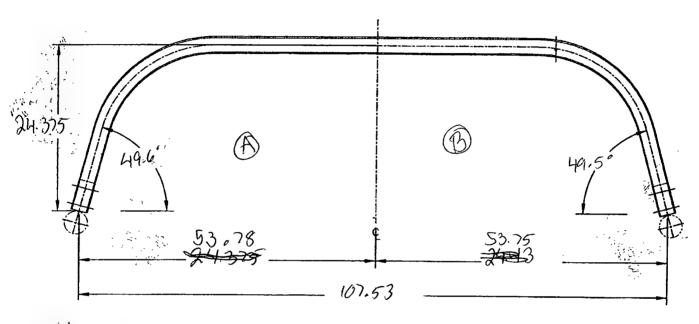
714.0000

Location	Loc Qty	Loc Code	
ST300	714		
117677	25		
118384	3		<u> </u>
118927	48		
119075	438		119075
120308	200		

Dart Ae	rospace	Ltd								,
W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	art No: PAR #:		Fault Cat	egory:	N	CR: Yes	No DQ	A:	Date:	
	Resolution:		Disposition: QA: N/C Closed: _				osed:	l: Date:		
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DART AEROSPACE LTD	Work Order:	84098
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: E		Page 1 of 1

Required Dimension	Min	Max		
Height	24.24	24.50		
1/2 Span	53.59	53.85		
Angle	49	52		
Total Span	107.18	107.70		



	ushing (A) 6.9 /2	Comments	
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53 C	161/3/j	Ø	
- A	QC15 Inspection	0	

Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM	
В	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	1/4
С	10.02.02	Dwg Rev updated	KJ 👭	1
	-8"			

W/O:		WORK ORDER CHANGES											
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Item	Qty -243	Part Number	Description
1	Х	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
2	1	D6009-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
6	2	D2856-600-1009	ABRASION STRIP
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTROMBELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6009-129

FINISHED LENGTH = 124.100±0 020 (BEFORE BENDING/TRIMMING)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4 2

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D412-664-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 47.0 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH. 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER OSI 035.
- 15) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0 005" MAY BE BLENDED OUT LONGITUDINALLY CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY **RETURN TO** ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 24098_4CJ 12/05/02

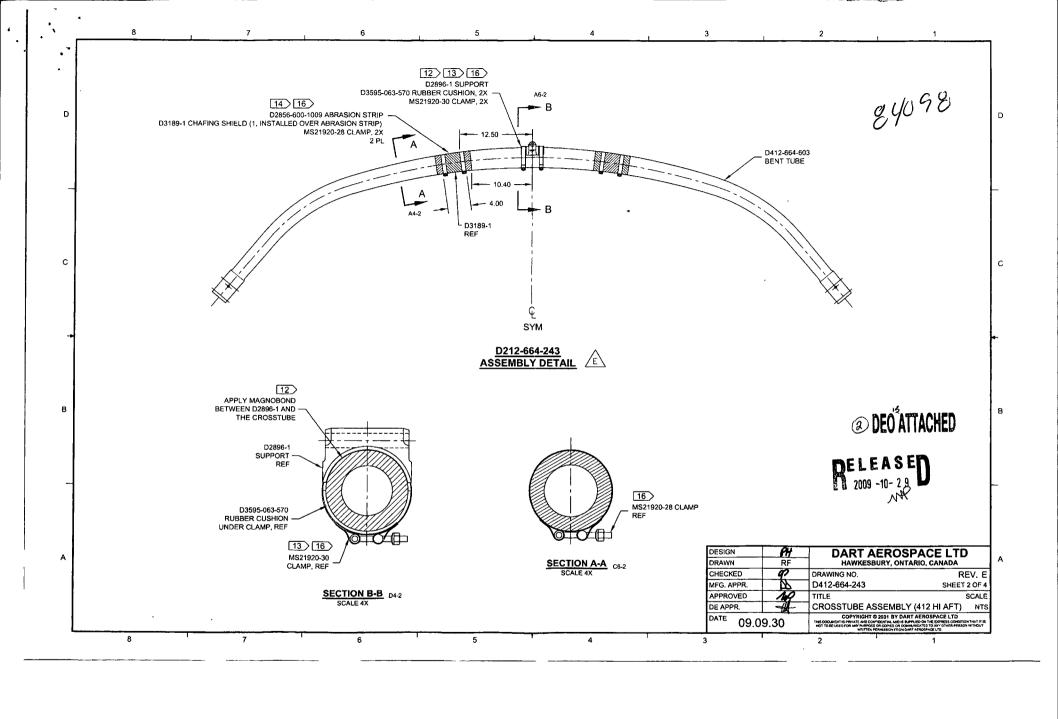
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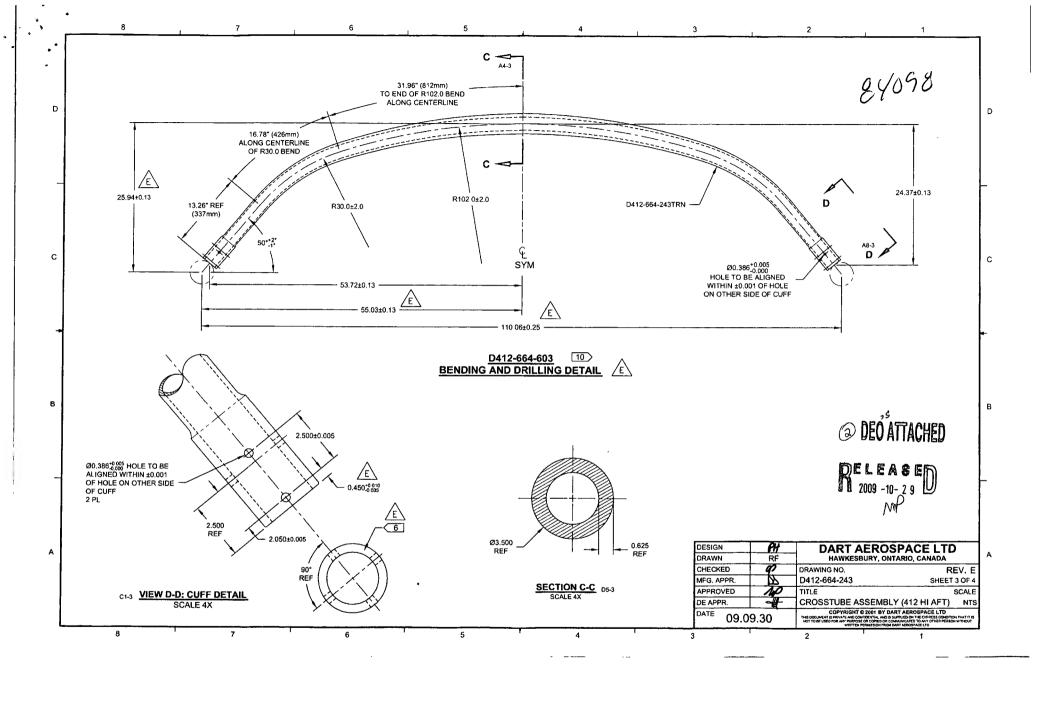
REFORMAT/REVISE GENERAL NOTES: 09 09 30 REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. D REMOVE D2732-058, CHANGE TO D3595-063-570 07.03.09 REMOVE D2856-600-1087. ADD D2732-058 & MB 06.10.27 MAGNOBOND 6398, MS21920-32 WAS MS21920-30 ADD HOLES FOR COMPATABILITY WITH BHT/AA 05.02.04 SKIDTUBES NEW ISSUE 01.10.17 PH REV. DESCRIPTION BY DATE

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APPROVED	10	TITLE	SCALE					
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT) NT						
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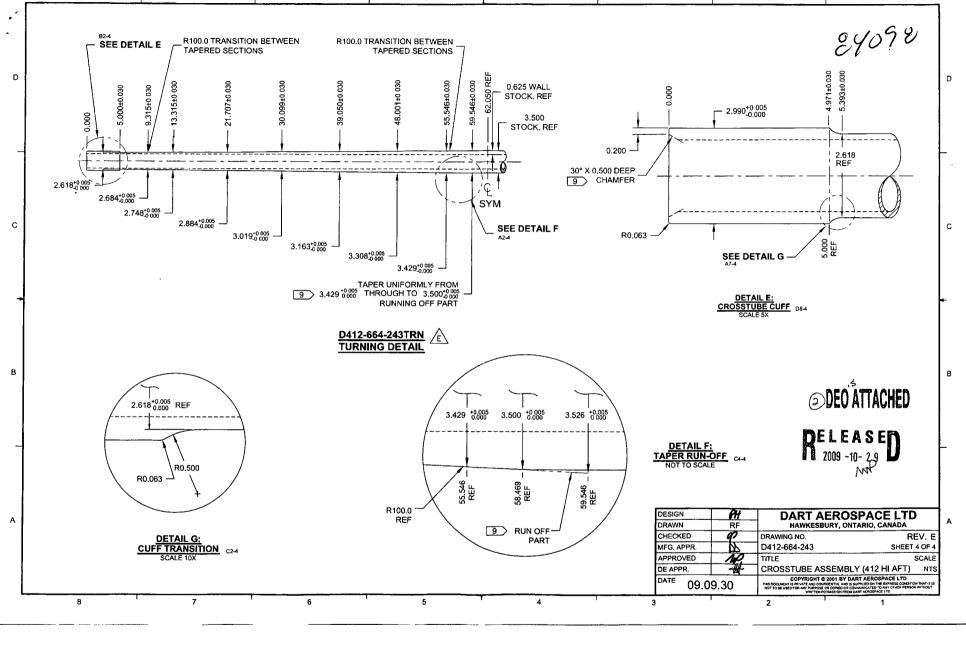
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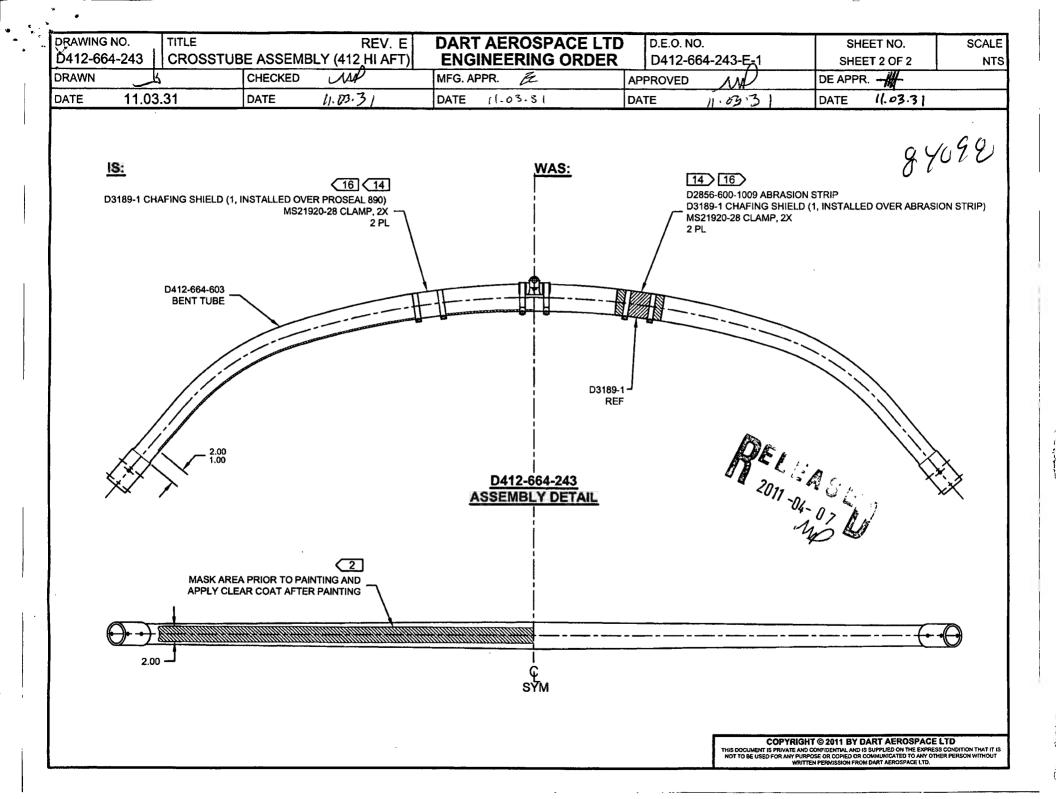
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DATE	11.09.07	DATE //. C	ろ.19 DATE	11.09.19	DATE	11.09.19	DATE /	1.09.19	

PURPOSE:

REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

24098

CHANGE:

S:

Item	Qty -243	Part Number	Description
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II. CLASS 2 ADHESIVE)

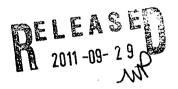
NOTE 12 & 16, SHEET 1 IS AMENDED AS FOLLOWS:

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- 12) INSTALL D2896-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

WAS:

- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.



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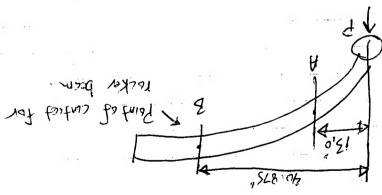
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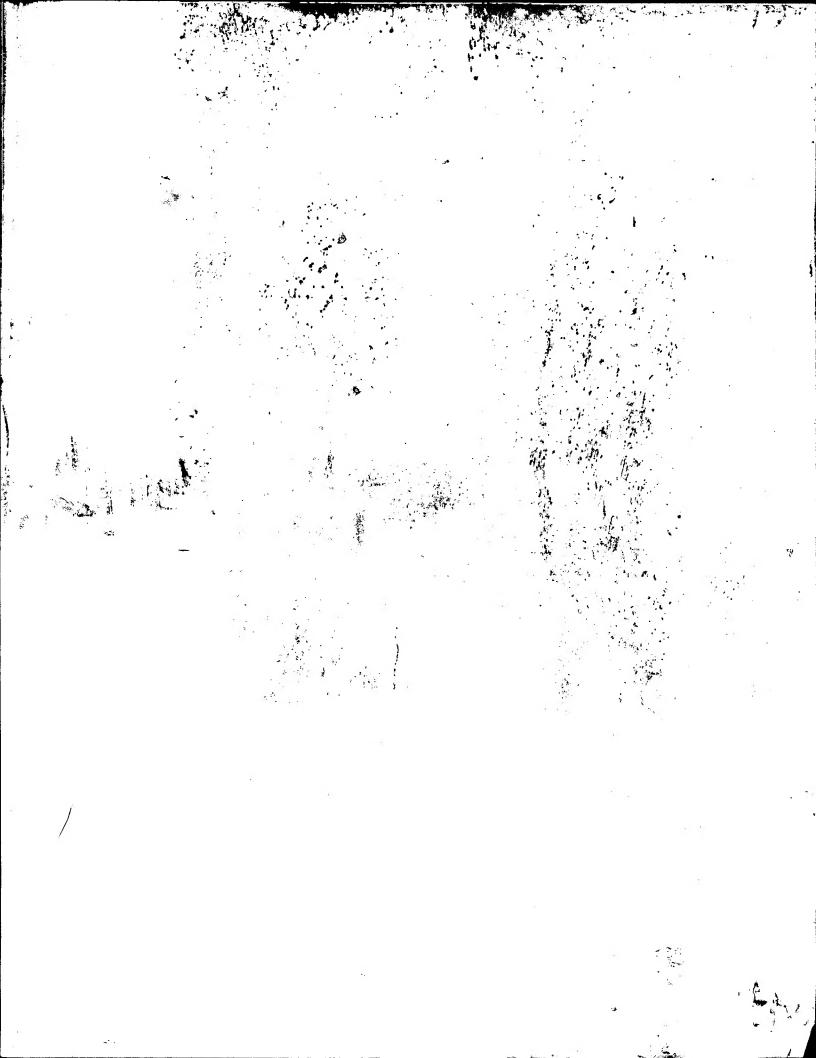
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In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed in implied, is made or intended by Acuren Group Inc. SIGNATURES CLIENT REPRESENTATIVE Mg Harry Urolged PRINT SIGNATURE REPORT REVIEWED BY: NAME (PRINT): NAME INITIALS NAME INITIALS SIGNATURE SIGNATURE SIGNATURE NAME INITIALS SIGNATURE SIGNATURE SIGNATURE NAME INITIALS SIGNATURE	1 -873 1 -873 1 -873 1 990 1 840 Scope of Services The agreement of Acuren Cothan all descriptions, commer representations or warrant data or other information produced in the control of	iroup Inc. to perform seents and expressions of iese. Acuren Group Inc. to provided by Acuren Gro	ervices extends only fopinion reflect the is not assuming an up Inc. In no event	to those services provi opinions or observatio y responsibilities of the shall Acuren Group In	ns of Acurer cowner/ope c.`s liability	rator and the in respect of	oasea on injorm owner/operator the services refe	retains complete res rred to herein exceed	ponsibility for ti d the amount pa	he engineering, mar id for such services	nufacture, repa	ir and use decisions as a resi
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